

Date: Wednesday, 1/18/2006 4:06:35 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARING ASSEMBLY
Job Number : 25561	
Estimate Number : 10716	
P.O. Number : N/A	Part Number : D3121241
This Issue : 1/18/2006 S.O. No. : N/A	Drawing Number : D3121 REV C2
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : C2
Previous Run : 25477	Material : N/A
	Due Date : 2/5/2006
Written By : <u>SEE COMMENT BELOW</u>	Qty: <u>40</u> Um: Each
Checked & Approved By : <u>SEE ABOVE DATE & USER</u>	
Comment : Est Rev:A 04.02.18 New issue KJ/DS	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MDELINR12500	DELIN ROUND BAR 1.25"
Comment: Qty.: 0.0431 f(s)/Unit Total : 1.7220 f(s) Material: Ø1.25 Delrin Rod <u>M16128 30"</u> (M-DELIN-R1.2500) Identify as D3121-25 Batch: <u>M100010 5"</u> <u>.052</u>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
Comment: HARDINGE CNC LATHE SMALL 1-Turn D3121-25 Cap as per Folio FA387 2-Deburr <u>BG 06.02.12 40</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>BG 06.02.12 40</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>S.G. 06/02/12 40</u>		
5.0	D312123	Bearing
Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s) Pick: <u>7 B25878</u> Qty Part Number Description Batch 1 D3121-23 Bearing <u>B25432</u> <u>X31</u> <u>BG 06.02.12</u>		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 06/02/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

SB 06/02/20

(7)

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

BG 06-02-12

31 + 9 u/o

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BG 06-02-12

31 + 9

Bearings
(41)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

st 409

06/2/21 (41)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

505 06/02/22

(41)

(41)
P. 06/02/22

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

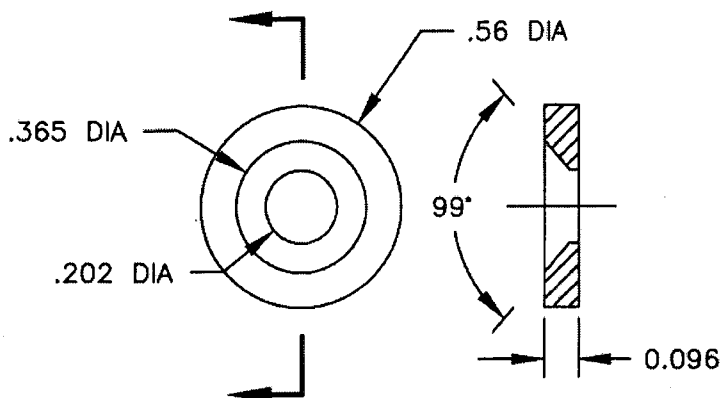
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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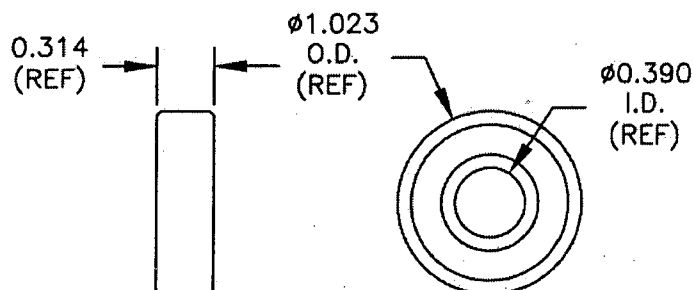
NOTE: Date & initial all entries

DART

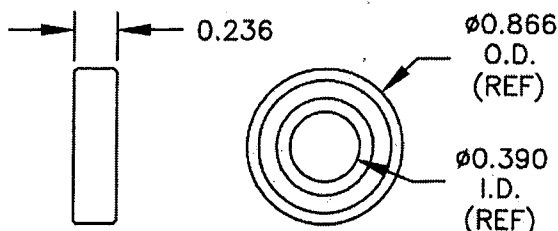
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3121	REV. C SHEET 10 OF 10
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

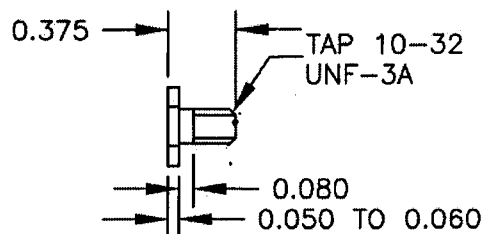
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

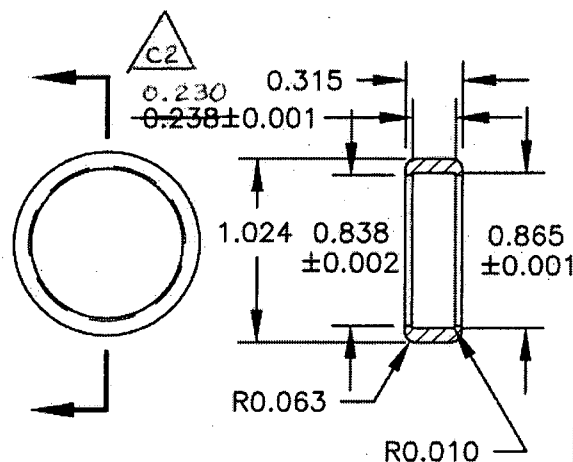
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

RELEASED
04.03.01

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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WORK ORDER
NO. 25561